

Date: Tuesday, 19/08/2008 4:04:24 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE		
Job Number	: 41441					
Estimate Number	: 10937					
P.O. Number	:					
This Issue	: 19/08/2008	S.O. No.	:	Part Number	: D29392	
Prsht Rev.	: NC			Drawing Number	: D2939 REV C	
First Issue	: / /	Type	: MACHINED PARTS	Project Number	: N/A	
Previous Run	: 39914			Drawing Revision	: C	
Written By	:			Material	:	
Checked & Approved By	<u>SLD 08-8-19</u>			Due Date	: 15/09/2008	
Comment	: Est: B 00.06.26 New DWG rev (mpp 2069) EC			Qty:	6	Um: Each
	Est Rev:C As per Rev C 07-03-19 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6101001	Saddle Billet	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) Issue material from stock: 7075-T7351 (QQ-A-250/12) Cut Size 2.0" x 6.25" X 6.00" Grain Along 6.00" Length Batch No: <u>B34872</u> <u>on 08/08/31</u> ⑥	
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Program part number and batch number. 1-Inspect part number and batch number are programmed correctly. 2-Machine Step No 1 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 3-Machine Step No 2 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 4-Machine Step No 3 of Folio and visually inspect as per dwg D2939 & attached Dimension Sheet 5-Deburr <u>on 08/08/31</u> ⑥	
3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
		Comment: CONVENTIONAL MILLING MACHINE Machine Keyway and inspect per attached dimension sheet <u>on 08/08/31</u> ⑥	
4.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET <u>on 08/08/31</u> ⑥	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:04:24 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206/OH-58 SADDLE, INBOARD, RIGHT SIDE

Job Number: 41441

Part Number: D29392

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

DDP 08/08/31

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Fd 08/09/02

(6)

7.0 POWDER COATING

POWDER COATING



M 108523



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 10:45

OF

OVEN TEMPERATURE: 320

00

FINISH TIME: 11:00

MF 08/09/02

(6)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Fd 08/09/02

(6)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 430

S 08/09/02 (x6)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 08-09-03

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41441
Description: 206 Saddle, Inboard, Right side	Part Number:	D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.125	.125	.123	.124	.125
B	0.100	0.140		.125	.122	.124	.124	.121
C	0.100	0.140		.112	.118	.116	.116	.116
D	0.210	0.230		.221	.222	.221	.221	.222
E	1.245	1.255		1.250	1.250	1.250	1.250	1.250
F	1.245	1.255		1.250	1.250	1.250	1.250	1.250
G	2.495	2.505		2.506	2.506	2.506	2.506	2.506
H	0.510	0.515		.516	.516	.516	.516	.516
I	1.572	1.582		1.576	1.577	1.577	1.577	1.577
J	2.495	2.505		2.499	2.500	2.500	2.506	2.500
K	0.257	0.262		.259	.259	.259	.259	.259
L	0.312	0.317		.315	.315	.314	.315	.315
M	0.235	0.240		.238	.236	.238	.238	.238
N	0.100	0.140		.122	.122	.122	.122	.123
O	0.540	0.560		.550	.552	.550	.550	.549
P	0.490	0.510		.503	.501	.502	.503	.503
Q	3.715	3.725		3.717	3.717	3.717	3.718	3.717
R	2.720	2.760		2.740	2.740	2.740	2.740	2.746
S	0.240	0.270		.251	.250	.250	.249	.248
T	0.100	0.180		.140	.140	.140	.140	.140
U	1.625	1.635		1.630	1.629	1.629	1.629	1.629
V	1.362	1.372		1.367	1.366	1.366	1.366	1.366
W	0.316	0.321		.320	.320	.320	.320	.320
X	1.250	1.270	1.260	1.260	1.260	1.260	1.260	1.260
Y	1.565	1.585	1.570	1.576	1.571	1.570	1.570	1.570
Z	0.178	0.198		.188	.188	.188	.188	.188
AA								
AB								
AC								
AD								

Accept/Reject

Measured by: KJL Date: 08/08/31

Audited by: DSR Date: 08/08/31

Prototype Approval: N/A Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD <u>JK</u>	<u>JK</u>

DART AEROSPACE LTD	Work Order: 41441
Description: 206 Saddle, Inboard, Right side	Part Number: D2939-2
Inspection Dwg: D2939 Rev: C DSK: Rev:	Page 1 of 1

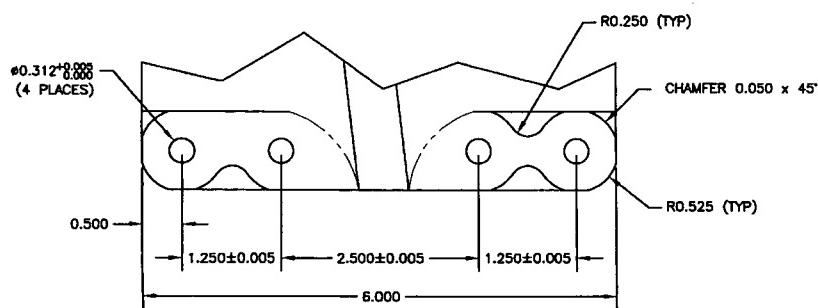
FIRST ARTICLE INSPECTION DIMENSION SHEET

First Article Prototype

Dim	Min	Max	Go/No Go Gauge	Record Actual Dimensions				
				1	2	3	4	5
A	0.100	0.140		.125				
B	0.100	0.140		.125				
C	0.100	0.140		.115				
D	0.210	0.230		.221				
E	1.245	1.255		1.250				
F	1.245	1.255		1.250				
G	2.495	2.505		2.500				
H	0.510	0.515		.510				
I	1.572	1.582		1.577				
J	2.495	2.505		2.506				
K	0.257	0.262		.259				
L	0.312	0.317		.314				
M	0.235	0.240		.237				
N	0.100	0.140		.122				
O	0.540	0.560		.549				
P	0.490	0.510		.503				
Q	3.715	3.725		3.717				
R	2.720	2.760		2.740				
S	0.240	0.270		.249				
T	0.100	0.180		.140				
U	1.625	1.635		1.629				
V	1.362	1.372		1.366				
W	0.316	0.321		.320				
X	1.250	1.270		1.260				
Y	1.565	1.585		1.570				
Z	0.178	0.198		.188				
AA								
AB								
AC								
AD								
Accept/Reject								

Measured by:	<i>SM</i>	Date:	08/08/31
Audited by:	<i>SD</i>	Date:	08/08/31
Prototype Approval:	N/A	Date:	N/A

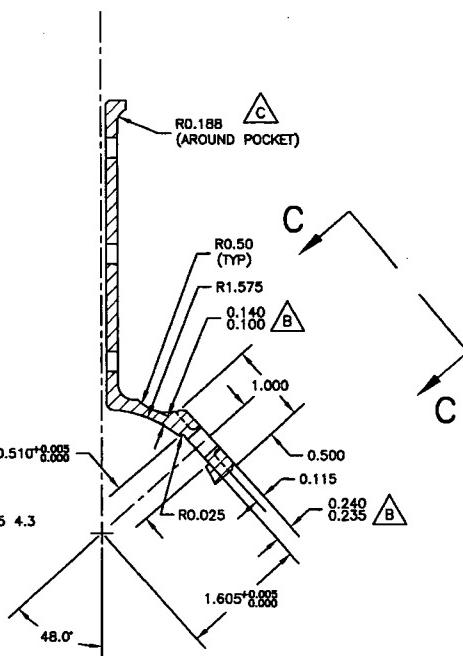
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	
D	07.11.23	DT8695 A/B removed	KJ/EC/DD <i>AF</i>	<i>DS</i>



VIEW C-C

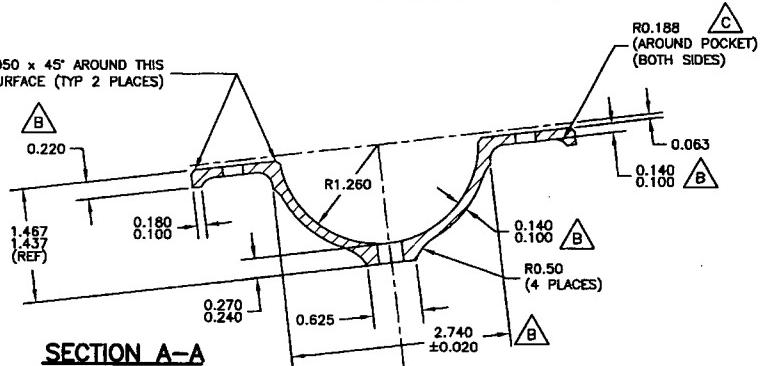
D2939-1 LH SADDLE (SHOWN)
D2939-2 RH SADDLE (OPPOSITE)

NOTES:
 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
 (MAKE FROM D6101-001 SADDLE BILLET, 7075)
 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 5) ALL DIMENSIONS ARE INCHES
 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

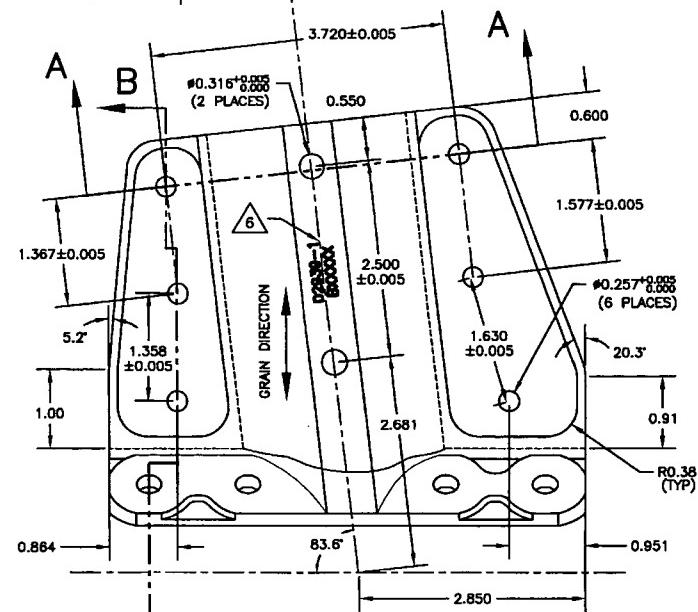


SECTION B-B

CHAMFER 0.050 x 45° AROUND THIS SURFACE (TYP 2 PLACES)



SECTION A-A



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.11.12	NEW ISSUE

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
4	CB	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. REV. C
PH	JK	D2939 SHEET 1 OF 1
DATE		TITLE SCALE
06.11.09		SADDLE INSIDE 2:3

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